



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4854-1

Job Sheet 170112



Part No: D4854-1

Job Qty: 10 ea

Part Name: Lower Bracket



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/10/18

Job Tracking No:

Due Date: 1/26/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Customer: Lohman Helicopter LLC (CLOHM01)

PO Box 976 Lewiston, ID, 83501 USA ph:(208) 743-5411 fx:(208) 413-9444.

Note: D4854 REV.B IPP REV:A NEW ISSUE 13-07-22 JLM VERIFIED BY:JFS IPP REV:B 17.12.08 AS PER DWG
REV.B DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		1/25/18	0.00	0.00	Start Up Waterjet		OK 18/01/14
100	Waterjet	10 pcs		1/25/18	0.05	2.50	Waterjet1		OK 18/01/14
105	QC	10 pcs		1/25/18	0.00	0.00	QC2 Waterjet-1		OK 18/01/14
110	Mill Conv	10 pcs		1/25/18	0.00	9.17	Mill Conv 1		J.C. 18-01-24
130	QC	10 pcs		1/25/18	0.00	0.00	QC8		OK 18/01/25
140	HandFinish	10 pcs		1/25/18	0.00	0.27	HandFinish1		20/8/01/25 JSC
150	QC	10 pcs		1/25/18	0.00	0.00	QC7-4		OK 18-01-25
160	Powdercoat	10 pcs		1/26/18	0.00	0.50	Powdercoat1		OK 18/01/25
170	QC	10 pcs		1/26/18	0.00	0.00	QC3		11
180	Packaging	10 pcs		1/26/18	0.00	0.00	Packaging3-2	17526	AT 18/01/28
190	QC21-SA	10 Ea		1/26/18	0.00	0.00	QC21		OK 18/01/29

Part Op 100 - CUT AS PER FILE DWG REV: B PROG REV: B DEBURR

Descriptions: 110 - MILL RADS DRILL HOLES AS PER DWG USE DT10105 ,ORIENT FIXTURE WITH RED FACE ON SAME SIDE
WHEN FLIPPING FIXTURE FROM SIDE TO SIDE OPEN SLOT TO .260" AS PER DWG DEBURR

160 - ***MASK AS PER DWG*** START TIME: 3:30 OVEN TEMPERATURE: 320° FINISH TIME:

4:00 PM 1/28/18

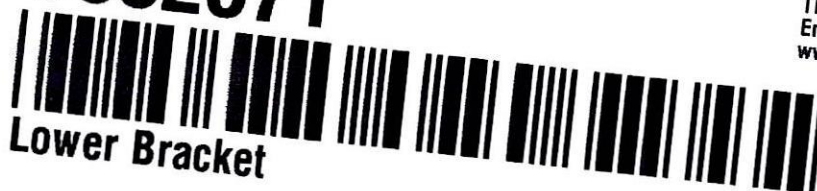
Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M6061T6B0.750X04.000	4	32	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Bracket	0.300Inches ± 0.030	0.330 0.270		
2	Lower Bracket	0.500Inches ± 0.030	0.530 0.470		
3	Lower Bracket	0.750Inches ± 0.030	0.780 0.720		
4	Lower Bracket	0.260Inches ± 0.005	0.265		

DART
AEROSPACE
S032571



Lower Bracket

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

PART NO: D4854 - 1
Original Serial #: S032571

Revision:

Operation:

Change No:

Start up Operation

01/16/18
Job No: 170112

			0.255	
5	Lower Bracket	3.500Inches ± 0.030	3.530 3.470	
6	Lower Bracket	2.200Inches ± 0.030	2.230 2.170	
7	Lower Bracket	4.450Inches ± 0.030	4.480 4.420	
8	Lower Bracket	0.257Inches $+ 0.005$ $- 0.000$	0.262 0.257	Diameter
9	Lower Bracket	3.700Inches ± 0.005	3.705 3.695	
10	Lower Bracket	0.257Inches $+ 0.005$ $- 0.000$	0.262 0.257	Diameter
11	Lower Bracket	1.880Inches ± 0.030	1.910 1.850	
12	Lower Bracket	1.250Inches ± 0.010	1.260 1.240	
13	Lower Bracket	0.380Inches ± 0.030	0.410 0.350	Radius
14	Lower Bracket	0.380Inches ± 0.030	0.410 0.350	Radius

Plex 1/10/18 12:25 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				